



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312

Job Sheet 180508



Part No: D350-591-312

Job Qty: 1 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/9/18

Job Tracking No: NOT AIRBUS

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/3/18	8/3/18	0.00	0.00	Start Up Large Fab-4		SLU
110	Large Fab	1 pcs	8/3/18	8/3/18	0.00	1.00	Large Fab 2		CPC
120	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC9		SA 18-07-24
130	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC5		CPC
140	HandFinish	1 pcs	8/3/18	8/3/18	0.00	0.19	HandFinish1		SA 18-07-24
150	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC7-2		CPC
180	Large Fab	1 pcs	8/3/18	8/3/18	0.00	1.00	Large Fab 2		CPC
190	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC10		SA 18-07-30
200	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC5		SA 18-07-30
210	HandFinish	1 pcs	8/3/18	8/3/18	0.00	0.19	HandFinish1		SA 18-07-30
220	Powdercoat	1 pcs	8/3/18	8/3/18	0.00	0.30	Powdercoat1		SA 18-07-30
230	HandFinish	1 pcs	8/3/18	8/3/18	0.00	0.19	HandFinish3		SA 18-07-30
240	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC3		SA 18-07-30
250	Packaging	1 pcs	8/3/18	8/3/18	0.00	0.00	Packaging1-3		SA 18-07-30
260	QC	1 pcs	8/3/18	8/3/18	0.00	0.00	QC4		SA 18-07-30
270	Packaging	1 pcs	8/3/18	8/3/18	0.00	0.00	Packaging3-1		SA 18-07-30
275	DC	1 pcs	8/3/18	8/3/18	0.00	0.00	DC		SA 18-07-30
280	QC21-FG	1 Ea	8/3/18	8/3/18	0.00	0.00	QC21		SA 18-07-30

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod M134785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M134785 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 6:30am OVEN TEMPERATURE: 320°F FINISH TIME: 9:00am

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	506954
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	508326
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	5091615
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOS Suspected Una			
Date : _____		Step #: _____			
Description Work Order Deviation					

Root Cause			FAULT CATEGORY					
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐					
Misidentified	☐	Past Due	☐	OTHER :				

DART
 AEROSPACE
 Container No: S091929
 Part: D350 - 591 - 312
 Job No: 180508
 Serial No/Batch: S091929
 Revision:
 Inspector:
 Exp Date:
 Instructions:
 Date: 07/16/18
 1270 Aberdeen Street
 Hamilton, ON K6A 1K7
 CANADA
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging
D2618	Bushing	2 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging

S088668
S079116

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	133	0
	D3219-1	2	123	0
	D3272-1	1	25	0
180-Large Fab	D3065-041	1	18	0
	D3066-1	2	178	0
	MS20600-AD4W4	16	3,204	0
250-Packaging	AN3-35A	2	380	0
	AN4-13A	8	2,267	0
	AN5-36A	2	324	0
	D2230-3	4	333	0
	D2618	2	208	0
	D2856-400-720	2	74	0
	D3235-1	2	273	0
	D3278-041	1	42	0
	MS21042L3	2	2,098	0
	MS21042L4	8	3,264	0
	MS21042L5	2	922	0
	NAS1149D0363J	4	1,624	0
	NAS1149D0463J	16	7,333	0
	NAS1149D0563J	4	1,638	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																												
Large Fab ☐	Composite ☐	Supplier ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															



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Tel (613) 632-5200

3 Aug
D350-591-312
Job Sheet 180508



Part No: D350-591-312

Job Qty: 1 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/9/18

Job Tracking No: NOT AIRBUS

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		AUG 01 2018 Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		8/3/18	0.00	0.00	Start Up Large Fab-4		SLK
110	Large Fab	1 pcs		8/3/18	0.00	1.00	Large Fab 2		CPC
120	QC	1 pcs		8/3/18	0.00	0.00	QC9		SLK
130	QC	1 pcs		8/3/18	0.00	0.00	QC5		SLK
140	HandFinish	1 pcs		8/3/18	0.00	0.19	HandFinish1		SA 18-07-24
150	QC	1 pcs		8/3/18	0.00	0.00	QC7-2		CPC
180	Large Fab	1 pcs		8/3/18	0.00	1.00	Large Fab 2		CPC
190	QC	1 pcs		8/3/18	0.00	0.00	QC10		SLK
200	QC	1 pcs		8/3/18	0.00	0.00	QC5		SLK
210	HandFinish	1 pcs		8/3/18	0.00	0.19	HandFinish1		SA 18-07-30
220	Powdercoat	1 pcs		8/3/18	0.00	0.30	Powdercoat1		SA 18-07-31
230	HandFinish	1 pcs		8/3/18	0.00	0.19	HandFinish3		BE 18-07-31
240	QC	1 pcs		8/3/18	0.00	0.00	QC3		
250	Packaging	1 pcs		8/3/18	0.00	0.00	Packaging1-3		
260	QC	1 pcs		8/3/18	0.00	0.00	QC4		
270	Packaging	1 pcs		8/3/18	0.00	0.00	Packaging3-1		
275	DC	1 pcs		8/3/18	0.00	0.00	DC		
280	QC21-FG	1 Ea		8/3/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod *M138851* 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod *M138851* 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: *8:30am* OVEN TEMPERATURE: *320°F* FINISH TIME: *9:00am*

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	<i>500150</i>
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	<i>500150</i>
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	<i>500150</i>
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	<i>500150</i>

1000 1000

D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging
D2618	Bushing	2 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging

DSI9410-011

1ea

50669
5079116
5067891x2
5089302
5071345
5103723
5082275
5092667
5089615
5095091
5089340
5089368
5058178
5068661
5089299
5093773
5081331

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	133	0
	D3219-1	2	123	0
	D3272-1	1	25	0
180-Large Fab	D3065-041	1	18	0
	D3066-1	2	178	0
	MS20600-AD4W4	16	3,204	0
250-Packaging	AN3-35A	2	380	0
	AN4-13A	8	2,267	0
	AN5-36A	2	324	0
	D2230-3	4	333	0
	D2618	2	208	0
	D2856-400-720	2	74	0
	D3235-1	2	273	0
	D3278-041	1	42	0
	MS21042L3	2	2,098	0
	MS21042L4	8	3,264	0
	MS21042L5	2	922	0
	NAS1149D0363J	4	1,624	0
	NAS1149D0463J	16	7,333	0
	NAS1149D0563J	4	1,638	0

DSI9410-011

1x

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004801	S067891	AN3-35A	Bolt	S067891	ST348	2
004801	S098316	AN4-13A	Bolt	S089302	OVER003	8
004801	S098315	AN5-36A	Bolt	S071345	ST336	2
004801	S098314	D2618	Bushing	S082275	ST008	2
004801	S098313	D2856-400-720	Abrasion Strip 4" X 7.20"	S092667	ST418	2
004801	S098312	D3235-1	Mounting Lug	S089615	ST522	2
004801	S098311	D3278-041	Support Assembly	S092091	ST522	1
004801	S098310	DSI 9410-011	Amends Installation Of D350-591-311/-312 Steps	S081331	FG123	1
004801	S098308	MS21042L3	Nut	S089340	ST303	2
004801	S098306	MS21042L4	Nut	S089365	ST303	8
004801	S098302	MS21042L5	Nut	S058178	ST303	2
004801	S098301	NAS1149D0363J	Washer	S068661	ST263	4
004801	S098300	NAS1149D0463J	Washer	S089299	ST263	16
004801	S098299	NAS1149D0563J	Washer	S093773	ST263	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 8/1/18 1:34 PM Dart.joly.jocelyne

D2230-3 Qty 4 S103723

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

THE UNIVERSITY

THE UNIVERSITY